

Date: Thursday, 04/12/2008 11:52:24 AM
 User: Chantal Lavoie

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : SADDLE BILLET (6061)
Job Number : 43917	
Estimate Number : 11989	
P.O. Number :	Part Number : D6102011
This Issue : 04/12/2008 S.O. No. :	Drawing Number : D6102 REV D
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : PURCHASED PARTS	Drawing Revision : D
Previous Run : 37601	Material :
Written By :	Due Date : 23/12/2008 Qty: 12 Um: Each
Checked & Approved By :	
Comment : Est. A 04.08.19 New issue KJ/JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PG	PURCHASING
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**Comment:** Issue P/O: 7758

- a) Description: Aluminum Billet
 b) 6.500" x 8.250" x 2.500" thick
 c) Tolerance on all dimensions is +0.06/0.00
 d) Grain direction along 6.500" length
 e) Material: 6061-T6/T6511 (QQ-A-250/11 or QQ-A-200/8)
 Material release certificate is required

C208112104

(12)

2.0	D6102011P	6061-T6 8.25x6.5x2.5
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 12.0000 Each(s)
 6061-T6 8.25x6.5x2.5

3.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1
 Receive & Inspect For Transit Damage
 Ensure material certification is attached

R 14/16 (12)

4.0	QC6	DIMENSIONAL CHECK
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Comment: DIMENSIONAL CHECK
 Check certification to Dwg D6102 for compliance

mf 08/12/17

(12)

5.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1
 Identify and Stock
 Location: _____

mf 08/12/17

(12)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE BILLET (6061)

Job Number: 43917

Part Number: D6102011

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



08/12/18 *[Signature]*

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-12-17

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

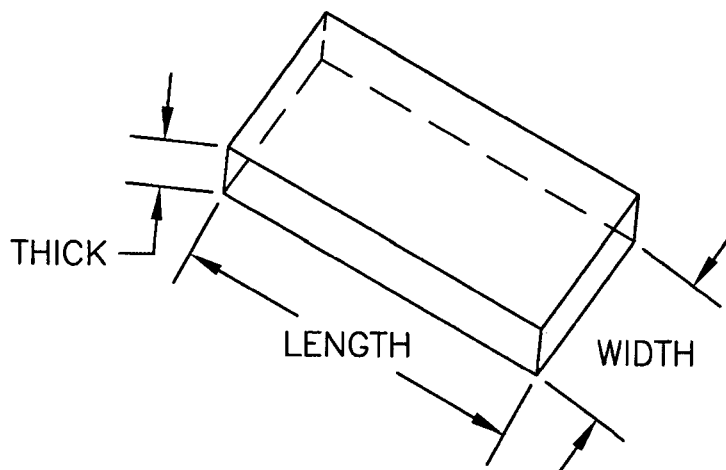
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN #	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED CP	APPROVED #	DRAWING NO. D6102	Rev. D SHEET 1 OF 1
DATE 06.06.30		TITLE SADDLE BILLET, 6061	SCALE NTS
A	01.03.30	NEW ISSUE	
B	03.10.20	ADD D6102-005/-007/-009	
C	04.08.25	ADD D6102-010/-011	
D	06.06.30	ADD D6102-013	

SPECIFICATION CONTROL DRAWING



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 43917

RELEASED

06.08.15 #

PURCHASE MATERIAL ACCORDING TO THE FOLLOWING TABLE. SPECIFY ALLOY, LENGTH x WIDTH x THICK (+0.06/-0.00), AND GRAIN DIRECTION AS SHOWN.

TOLERANCE ON ALL DIMENSIONS IS +0.06/-0.00.

ALL DIMENSIONS ARE IN INCHES.

Part No.	Alloy	Length	Width	Thick	Grain Direction
D6102-001	6061-T6/T651 (QQ-A-250/11 or QQ-A-200/8)	7.880	6.250	2.000	Along 7.880 Length
D6102-003	6061-T6/T651 (QQ-A-250/11 or QQ-A-200/8)	6.000	6.250	2.000	Along 6.000 Length
D6102-005	6061-T6/T651 (QQ-A-250/11 or QQ-A-200/8)	47.85	15.250	1.000	Along 47.85 Length
D6102-007	6061-T6/T651 (QQ-A-250/11 or QQ-A-200/8)	7.500	7.000	2.500	Along 7.500 Length
D6102-009	6061-T6/T651 (QQ-A-250/11 or QQ-A-200/8)	11.000	6.000	5.000	Along 11.000 Length
D6102-010	6061-T6/T651 (QQ-A-250/11 or QQ-A-200/8)	7.950	8.250	2.500	Along 7.950 Length
D6102-011	6061-T6/T651 (QQ-A-250/11 or QQ-A-200/8)	6.500	8.250	2.500	Along 6.500 Length
D6102-013	6061-T6/T651 (QQ-A-250/11 or QQ-A-200/8)	6.500	7.000	2.000	Along 6.500 Length

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REQUISITION CLIENT-CUSTOMER REQUISITION NO.

NO. COM. CLIENT-CUST. ORD. NO.

COMPTE-ACCT.

VEND. SLS

TERR.

EXPÉDIE PAR-SHIP VIA

7758

91037

200

50

MANITOULIN

ACHETEUR-PURCHASING AGENT

HANTAL

TELEPHONE

413 632-3336

H/C

TAXE

NO. COM ORD

1

C/C

REGION LIVRAISON-DEL ZONE

F.A.B.-F.O.B.

BILL

NO. FEVILLE/EMBALLAGE-B/L NUMBER

RE A-SHIP TO:

VENDU A-SOLD TO:

DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY

ON K6A 1K7

INFORMATION CRÉDIT-CREDIT INFORMATION

ROUTE

01-NL-12/11
30-NL-12/15
31-NL-12/16

INSTRUCTIONS/LIVRAISON-DELIVERY

NO-L89371

INSTRUCTIONS LIVRAISON (CONT.)-DELIVERY (CONT'D.)

INSTRUCTIONS LIVRAISON (CONT.)-DELIVERY (CONT'D.)

DESCRIPTION - ITEM 1

2.5000 PLATE 6061-T651 ALUM 8.25" X 6.50"

BLUE

QTE/UNITE COM.-ORDERED

12 PCS

PCES/PO COM.-ORD

PCS

POIDS COM.-WT. ORDERED

160

BALLOTS-BUNDLES

PCES/PO EXP. SHP.

POIDS EXP.-WT. SHIPPED

1

12

160

CERTIFICATE OF CONFORMANCE

INSTRUCTIONS

TOL: +.0030"/-.0000"

GRAIN TO RUN ALONG 6.50"
PRIOR DIST/ORD: 01 706840

COULÉE INFO-HEAT INFO QTE-QTY

301141

FORME-SHAPE

I.A.C.

35.81050F

14670

A.M. Castle & Co. certifies that the material(s) supplied under this document will meet and conform to the specifications of the product(s) described hereon.
A.M. Castle & Co. (Canada) Inc.

WEIGHT FOR SHIPPING PURPOSES ONLY. SEE INVOICES FOR ACCURATE BILLING WEIGHT. PLEASE SIGN AND DATE DRIVER'S COPY FOR RECEIPT OF MATERIAL AND, IF CHECKED, TEST REPORTS.

INSTRUCTIONS (CONT'D.)

8.25 x 6.50"

N3

ENT.-WHS

DESCRIPTION - ITEM 2

QTE/UNITE COM.-ORDERED

PCES/PO COM.-ORD

POIDS COM.-WT. ORDERED

BALLOTS-BUNDLES

PCES/PO EXP. SHP.

POIDS EXP.-WT. SHIPPED

TERMS AND CONDITIONS OF SALE

SEE DISCLAIMERS AND LIMITATIONS ON THE REVERSE SIDE

INSTRUCTIONS

1 SKID

COULÉE INFO-HEAT INFO QTE-QTY

INSTRUCTIONS (CONT'D.)

FORME-SHAPE

I.A.C.

ENT.-WHS

DESCRIPTION - ITEM 3

QTE/UNITE COM.-ORDERED

PCES/PO COM.-ORD

POIDS COM.-WT. ORDERED

BALLOTS-BUNDLES

PCES/PO EXP. SHP.

POIDS EXP.-WT. SHIPPED

ALL EXCEPTIONS FOR SHORTAGE OR DAMAGE MUST BE NOTED ON THE DRIVER COPY & CUSTOMER COPY OF THE DELIVERY RECEIPTS & SIGNED BY THE DRIVER & CUSTOMER. COPY OF SUCH RECEIPT PROPERLY NOTED MUST BE SUBMITTED WITHIN 10 DAYS WHEN CREDIT IS REQUESTED.

INSTRUCTIONS

COULÉE INFO-HEAT INFO QTE-QTY

INSTRUCTIONS (CONT'D.)

FORME-SHAPE

I.A.C.

ENT.-WHS

NOM (LETTRE MOULÉE)-NAME (PRINT ONLY)

RECU PAR-RECEIVED BY

DATE RECU-
DATE RECEIVED

FEVILLE D'EMBALLAGE - PACKING SLIP

T-033 P027038 F-384

316-522-3453

09-30-'08 07:47 FROM-Castle Metals

CERTIFIED INSPECTION REPORT

Alcoa Inc.

PITTSBURGH, PA DAVENPORT WORKS

Ship From: RIVERDALE, IA.

We hereby certify that the material covered by this certificate has been inspected with, and has been found to meet, the applicable requirements described therein, including any specifications forming a part of the description and that samples representative of the material met the composition limits and had the mechanical properties shown on the face of this sheet.

Per:

Melcolm Murphy

Director of Manufacturing Davenport Works

Kendon P. Young

Quality Assurance Manager

964668

Ship Date

0

B.L. No.

Invoice No.

Alcoa No. Item

Page 1

2008-09-24

3147817

00000

5206227-2

P.O. No./Govt Contract No.

Customer

Alcoa Item

Mfg Order

23-14329

CASTLE A M G041001897R05 DS-06227-1

Ship To: A M CASTLE & COMPANY
3050 SOUTH HYDRAULIC
NICHITA 67216 KS

Item Description

2.5 IN TK (+.0750 -0.0000) X 48.5 IN W (+.3125 -0.0000) X 144.5 IN LN (+.5 -0.0) CAT D 124420 (N) A/T 6061-
T651 TYPE 200 WROUGHT TOOLING PLATE MILL FINISH,
SAWED 1AC 14670 AMS4027 REV N ANSIN35.2 REV 2006 EXC_MRK ASME-SB-
209 REV 07 EXC_MRK ASTM209 REV 07
(MARKED) KRAFT PAPER INTERLEAVED
MAX GROSS SKID WGT: 3750 LB QUAN TOL +/-
25 % CQR 0042580 REV 35 CUST REQ 08-08-
25 *** W/E 08-09-06 ***

Num	Package Ticket	Lot	Weight	Quantity	UOM	Pc Id/Serl
1	677208	301141 ✓	3485	2	PC	:

CQR: 0042580.35 -Specification Limits

Temp	Dir	Max	Min	UTS KSI	TYS KSI	ELAD PCT
T651	Long Transv.			42.0	35.0	6

Chemical Composition		SI	FE	CU	MN	MG	CR	ZN	TI	Other Each	Other Total	Aluminum
Alloy	6061	Max	0.8	0.7	0.40	0.15	1.2	0.35	0.25	0.15	0.05	0.15
Lot:	301141	Min	0.40		0.15		0.8	0.04				REMAIN

- Mechanical, Physical, Metallography, Quantometer Results

Temp	Dir	No->	Test	UTS KSI	TYS KSI	ELAD PCT
T651	Long Transv.	5		48.8	43	13.5
				49	43.2	14.2
				48.8	43	13.5
				48.8	43	14.1
				48.9	42.8	13.5

CASTLE METALS-WIG

DATE REC'D

REC'D FROM

APPROVED BY

9-25-08
5170
8

T-033 P028/038 F-384

316-522-3453

09-30-'08 07:48 FROM-Castle Metals

CERTIFIED INSPECTION REPORT

Alcoa Inc.

PITTSBURGH, PA DAVENPORT WORKS

Ship From: RIVERDALE, IA.

We hereby certify that the material covered by this certificate has been inspected with, and has been found to meet, the applicable requirements described therein, including any specifications forming a part of the description and that samples representative of the material met the composition limits and had the mechanical properties shown on the face of this sheet.

Per:

Malcolm Murphy

Director of Manufacturing Davenport Works

Kenton P. Young

Quality Assurance Manager

954668	0				
Ship Date	B.L. No.	Invoice No.	Alcoa No.	Item	Page 2
2008-09-24	3147817	00000	5206227-2		
P.O. No./Govt Contract No.	Customer	Alcoa Item	Mfg Order		
23-14329	CASTLE A M	G041001897R05	DS-06227-1		

Lot: 301141 - Mechanical, Physical, Metallography, Quantometer Results (cont.) -----
 Cast Number Chemical - OBS SI FE CU MN MG CR ZN TI
 08L02924 Actuals 0.63 0.5 0.27 0.02 1.1 0.19 0.01 0.02

This material was melted in the United States or a Qualifying Country [REF OFARS 225.872.1(a)]; it was manufactured in the United States

